

Date: Wednesday, 30/07/2008 5:29:51 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT FACING SEAT ASS'Y LH		
Job Number	: 40821			Part Number	: D412769043		
Estimate Number	: 13306			Drawing Number	: D412-769-1 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 30/07/2008 S.O. No. :			Drawing Revision	: B		
Prsh Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 15/08/2008 Qty: 1 Um: Each		
Previous Run	: 40820						
Written By	:						
Checked & Approved By	: <u>JP 08-7-31</u>						
Comment	: Est rev A 08-05-12 new issue DD verified by:EC Est Rev:B 08-07-17 revB as per dwg DD verified by:ec						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
2.0	D3782045	Back Leg Assembly	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Back Leg Assembly batch: <u>B40873-3</u>	
3.0	D3782041	Front Inboard Leg Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Inboard Leg Assembly batch: <u>B40870</u>	
4.0	D3782043	Front Outboard Leg Assembly, LH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Outboard Leg Assembly, LH batch: <u>B40871</u>	
5.0	D3783041	Lateral Brace Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lateral Brace Assembly batch: <u>B40874</u>	

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/07/2008 5:29:51 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40821

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :	
6.0	D3783043	Longitudinal Brace Assembly	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Longitudinal Brace Assembly batch: B40875	SP
7.0	D3783045	Angle Brace Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Angle Brace Assembly batch: B40876	SP 08/08/09
8.0	D3784041	Seat Support Assembly, Center	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Support Assembly, Center batch: B40877	SP 08/08/09
9.0	D3784043	Seat Support Assembly, LH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Support Assembly, LH batch: B40878	SP
10.0	D3784044	Seat Support Assembly, RH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Support Assembly, RH batch: B40879	SP
11.0	D37661	Front Rail, LH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Rail batch: B40863	SP
12.0	D37663	Rear Rail	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rear Rail batch: B40865	SP 08/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40821

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 D37671 Upper Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: 40866

SP

14.0 D37921 Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch: 40999

① ②

SG

15.0 AN415A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M104746

SP

16.0 AN45 13A EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M109013

SP

17.0 AN510A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M108471

SP

18.0 AN513A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108167

① ②

SP

19.0 AN960JD10 Washer



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

batch: 1109059

(or NAS1149D0363J) batch: M109059

FF 08/08/27 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40821

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 AN960JD416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108161

(or NAS1149D0463J) batch: \_\_\_\_\_

SP

21.0 AN960JD516 Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M108678

(or NAS1149D0568J) batch: \_\_\_\_\_

SP

22.0 AN52510R24 Screw



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M108270

SP

23.0 MS21042L3 Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M108701

SP

24.0 MS21042L4 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M107499

SP

25.0 MS21042L5 Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M108471

8/8/21

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40821

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

26.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-1

FF 08/08/27 ①

27.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/08/27 ①

28.0 POWDER COATING

POWDER COATING



M106442



Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-1

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:15

OVEN TEMPERATURE:

320°

FINISH TIME:

10:45

ML 08/08/28

29.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-28 X

30.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0 D37751

Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guard

batch: B40658

SB 08/08/29 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY LH

Job Number: 40821

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

32.0 D37741 Seat Bottom, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: B40867

SB 08/08/29 (1)

33.0 D37743 Seat Back, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: B40868

SB

34.0 AN525 10R22 Screw



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

batch: M107936

SB

35.0 AN960JD10L Washer



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

batch: M105793

(or NAS1149D0332J) batch:

SB

36.0 MS21042L3 Nut



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Nut

batch: M108701

SB

37.0 AN35A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M100188

SB 08/08/29 (1)

38.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install remaining parts as per dwg D412-769-1

FF 08/08/29 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40821

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

39.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/28 (X)

40.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP40805

JS 08/08/29 (X)

41.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Heshe/25

Job Completion



MF 08-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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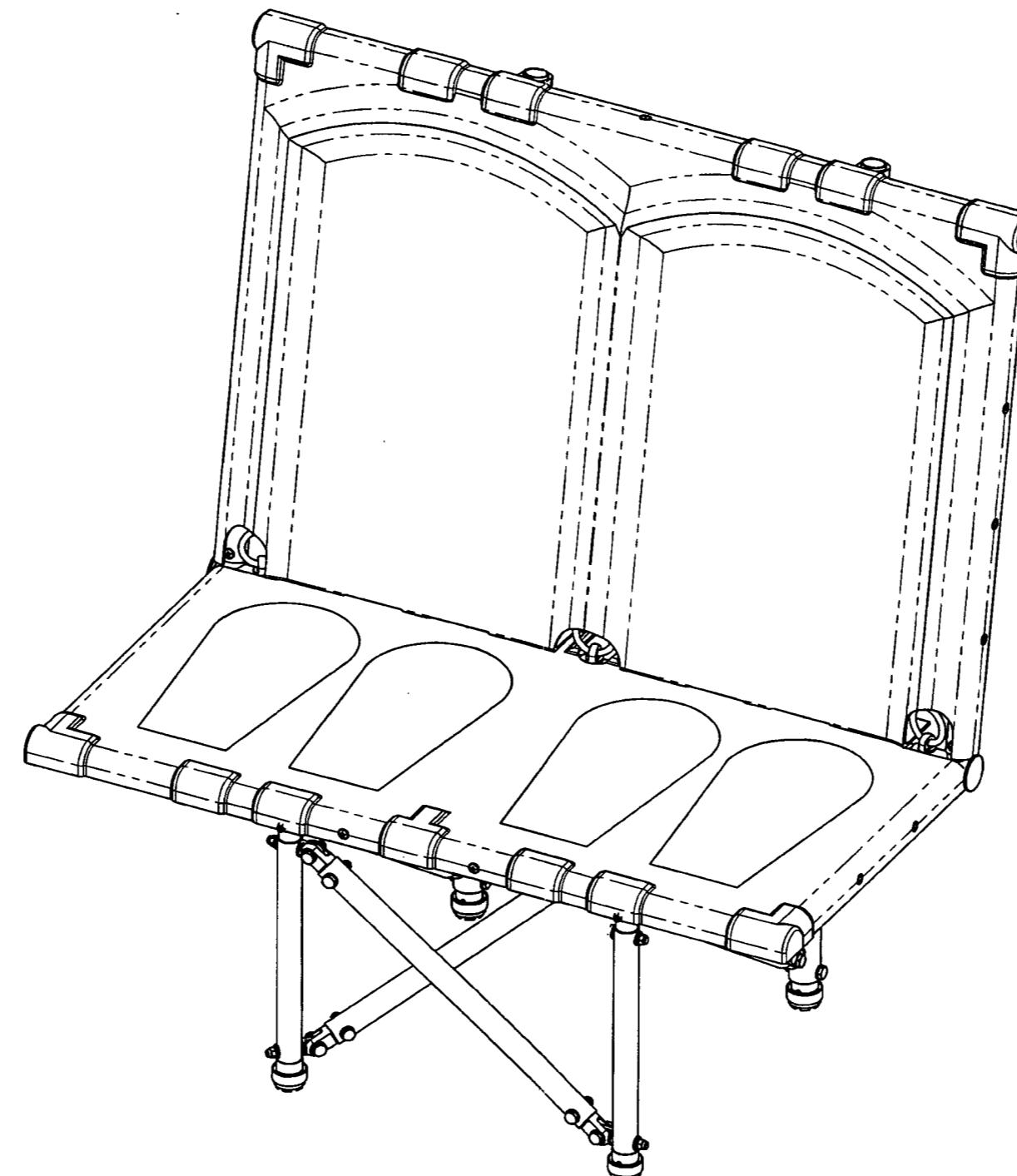
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D412-769-043 AFT FACING SEAT ASSY, LH

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 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 40821

RELEASED  
 08.07.09  
 MP

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		BY DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	AA	D412-769-1	SHEET 1 OF 7
APPROVED	MP	TITLE	SCALE
DE APPR.	AA	AFT FACING SEAT ASSY, LH	
DATE	08.06.25	NTS	

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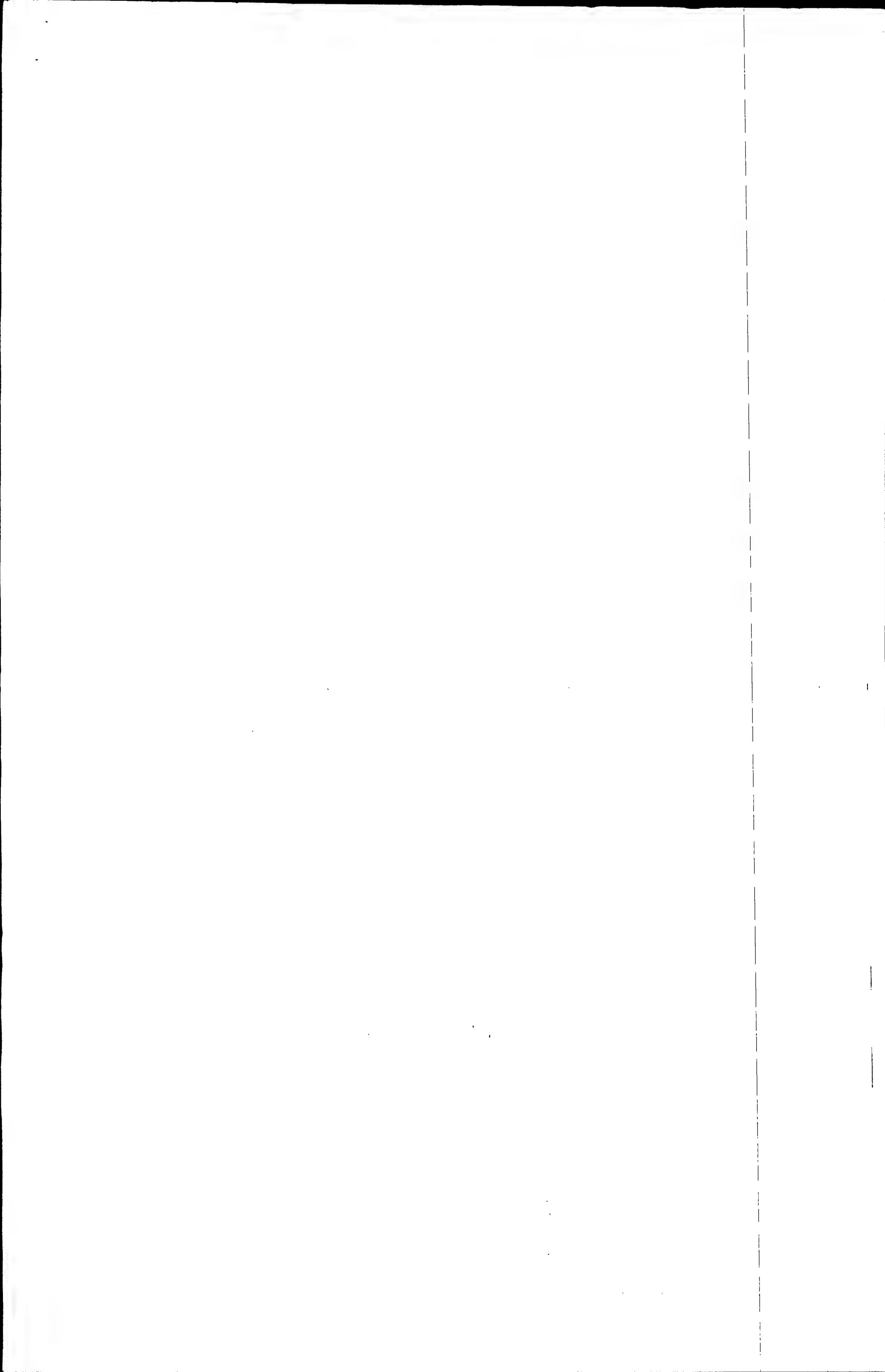
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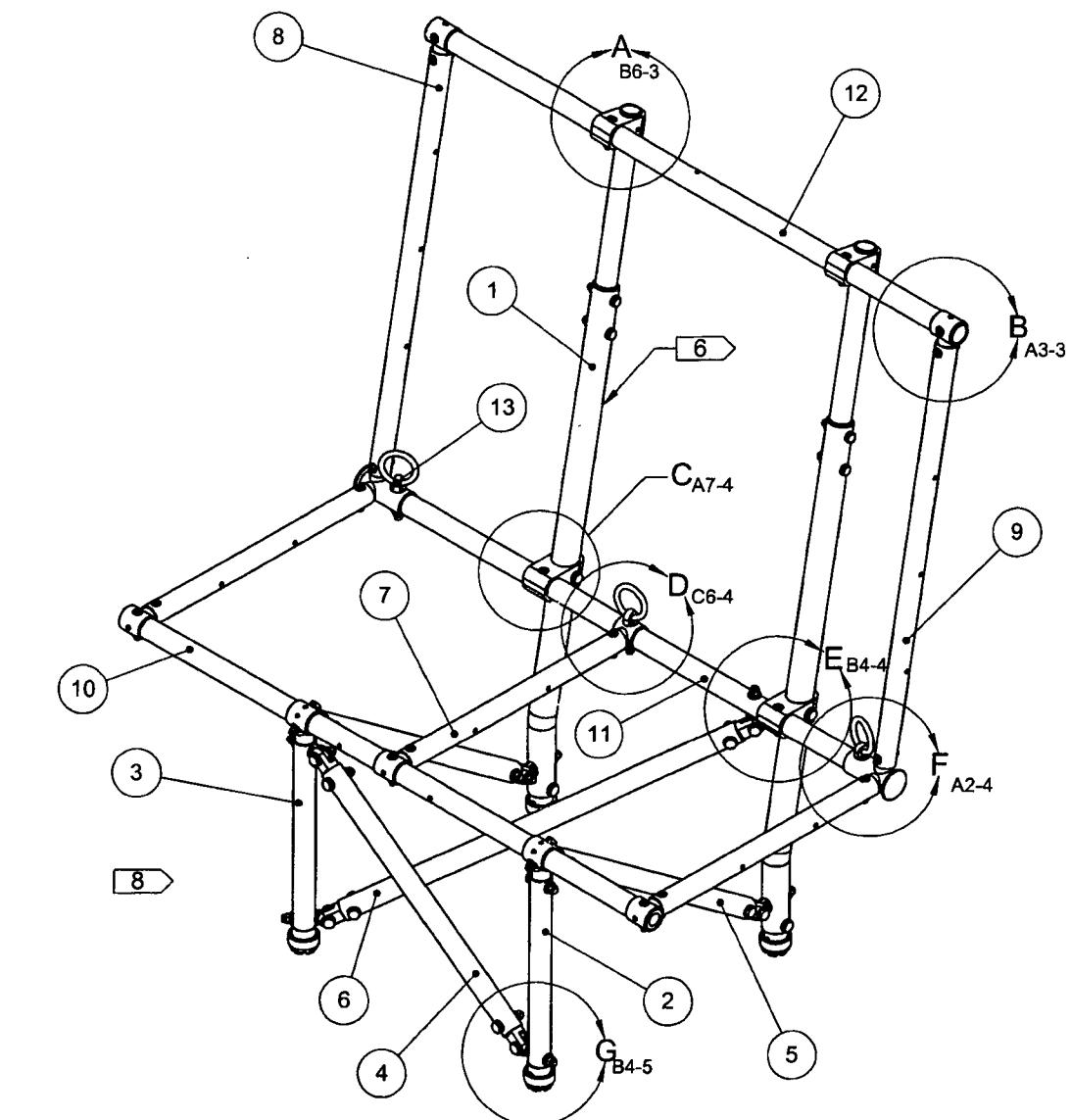
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-1	FRONT RAIL, LH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20



D412-769-043 AFT FACING SEAT ASSY, LH

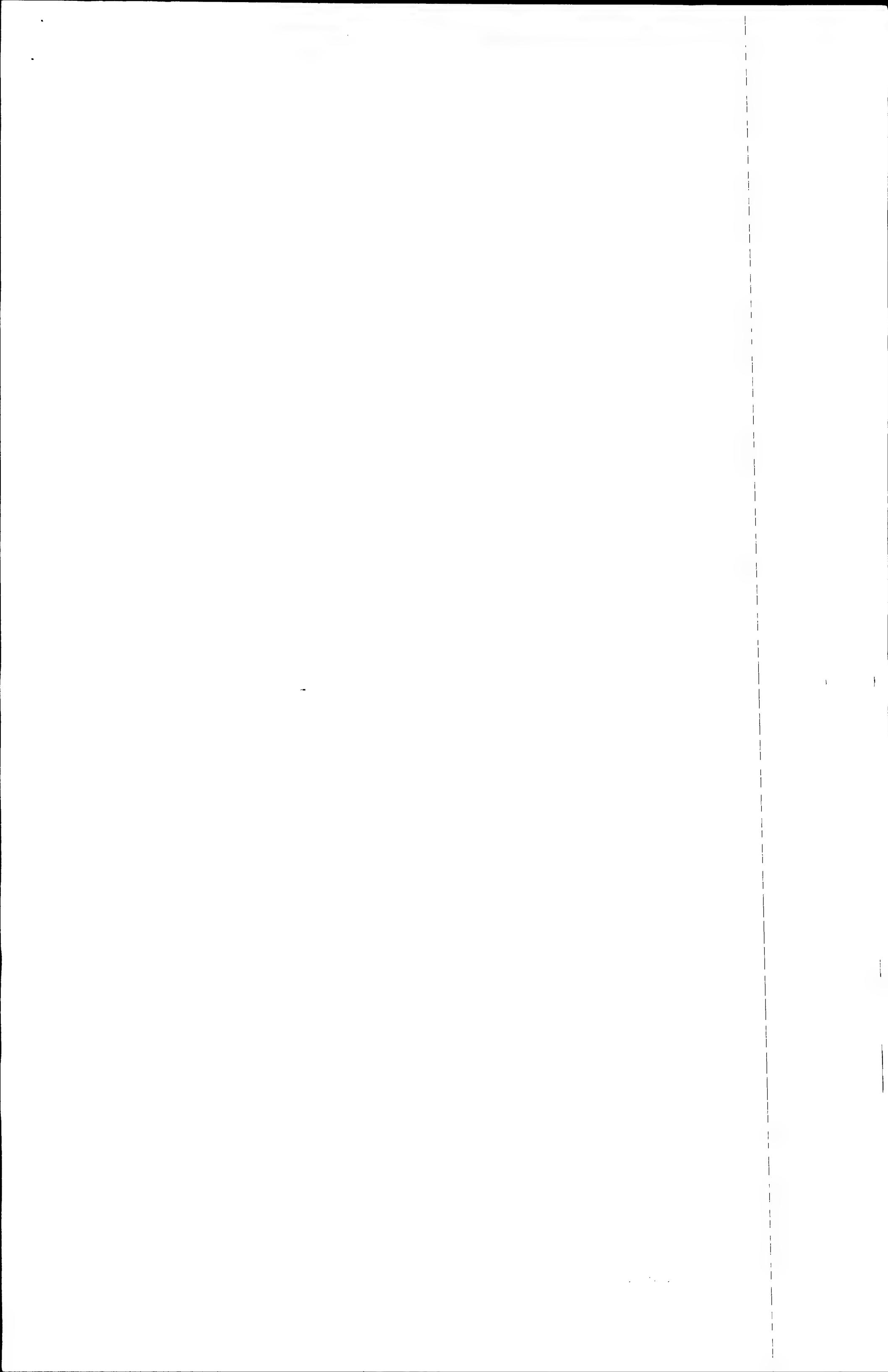
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10821

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NO. 10821

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/3). MASK FRONT LEGS PRIOR TO POWDER COAT.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED		DRAWING NO. D412-769-1
MFG. APPR.		REV. B
APPROVED		SHEET 2 OF 7
DE APPR.		TITLE
DATE	08.06.25	SCALE NTS
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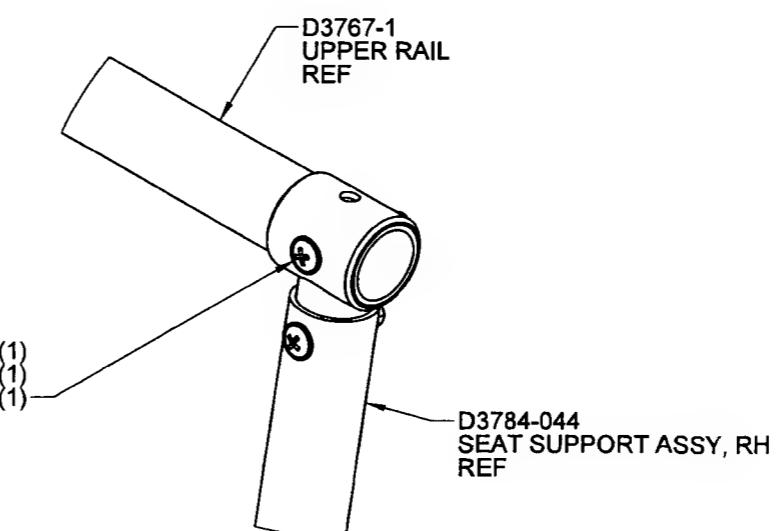
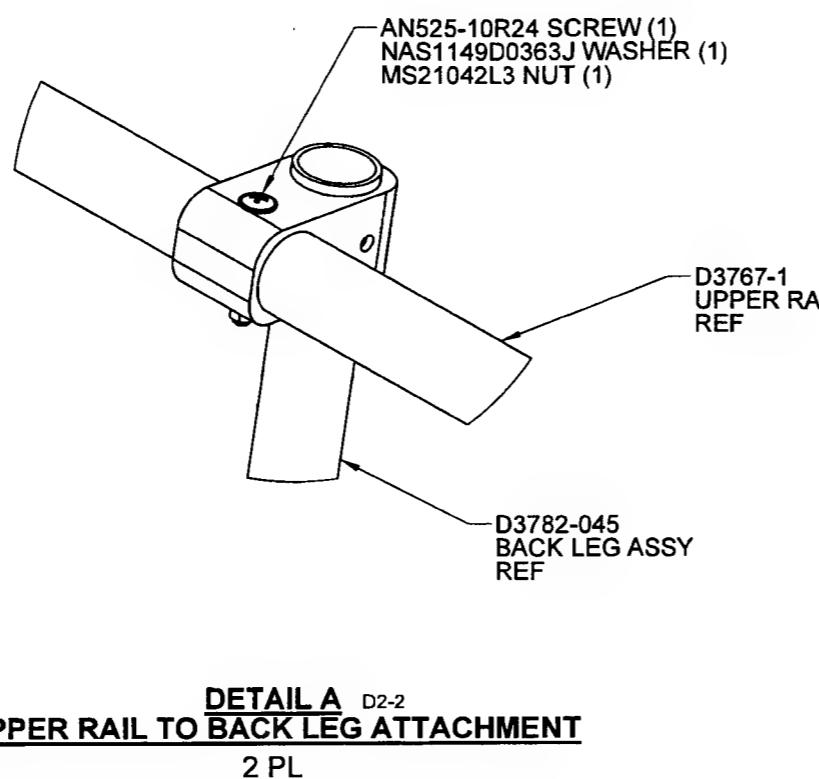
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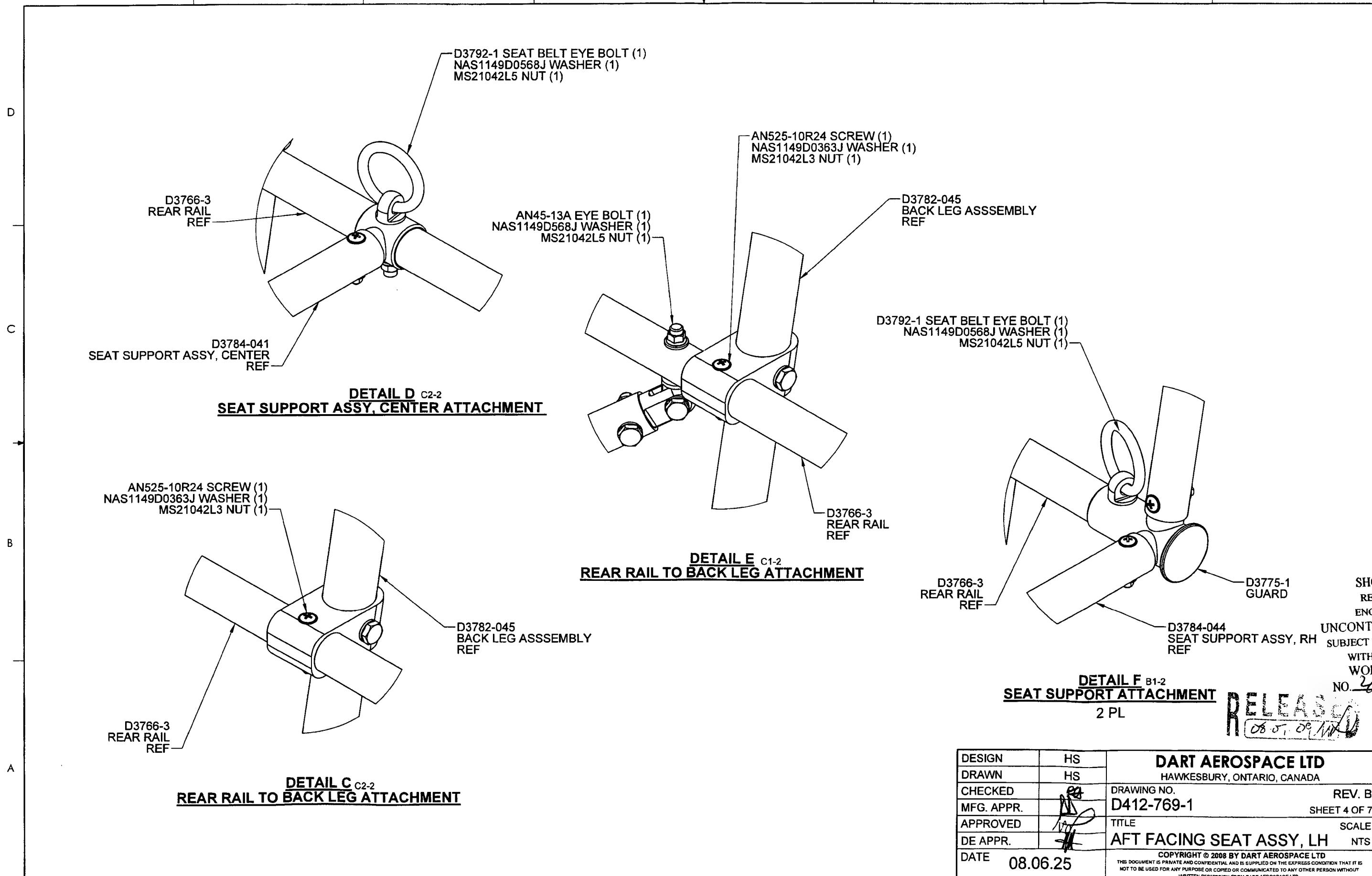


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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	
MFG. APPR.	AS	D412-769-1	
APPROVED	AS	REV. B	
DE APPR.	AS	SHEET 3 OF 7	
DATE	08.06.25	SCALE	NTS
AFT FACING SEAT ASSY, LH			
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DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D412-769-1 TITLE AFT FACING SEAT ASSY, LH SCALE NTS
DRAWN	HS	
CHECKED	ea	
MFG. APPR.	MA	
APPROVED	TA	
DE APPR.	SH	
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08.07.08  
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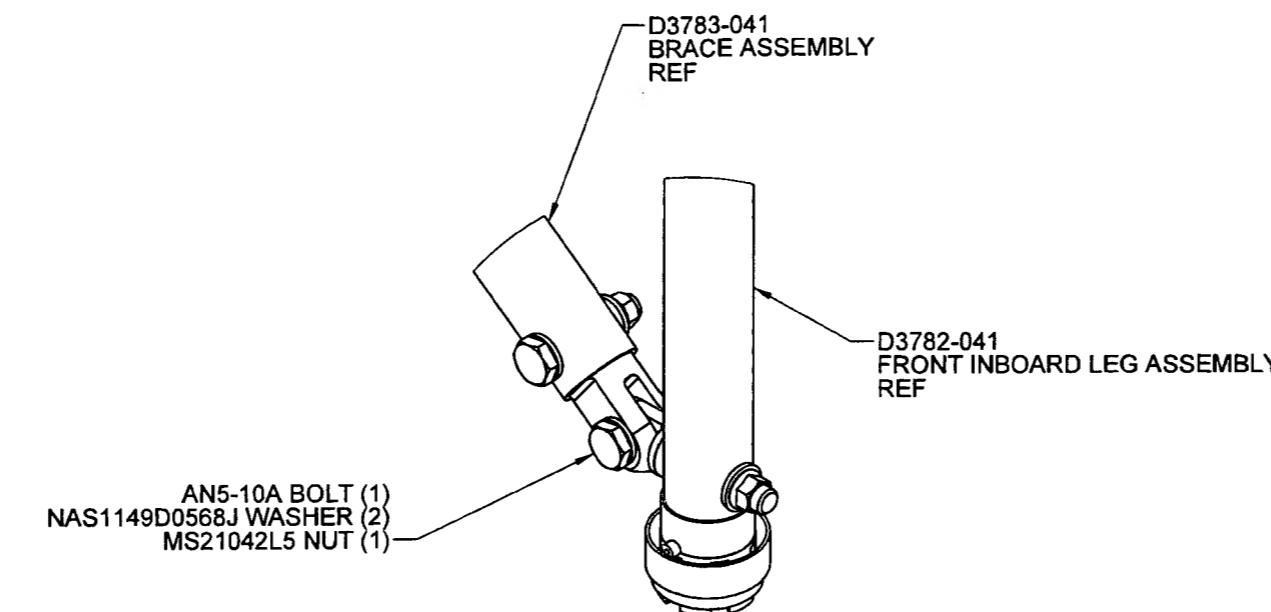
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DETAIL G<sub>B2-2</sub>  
BRACE ATTACHMENT

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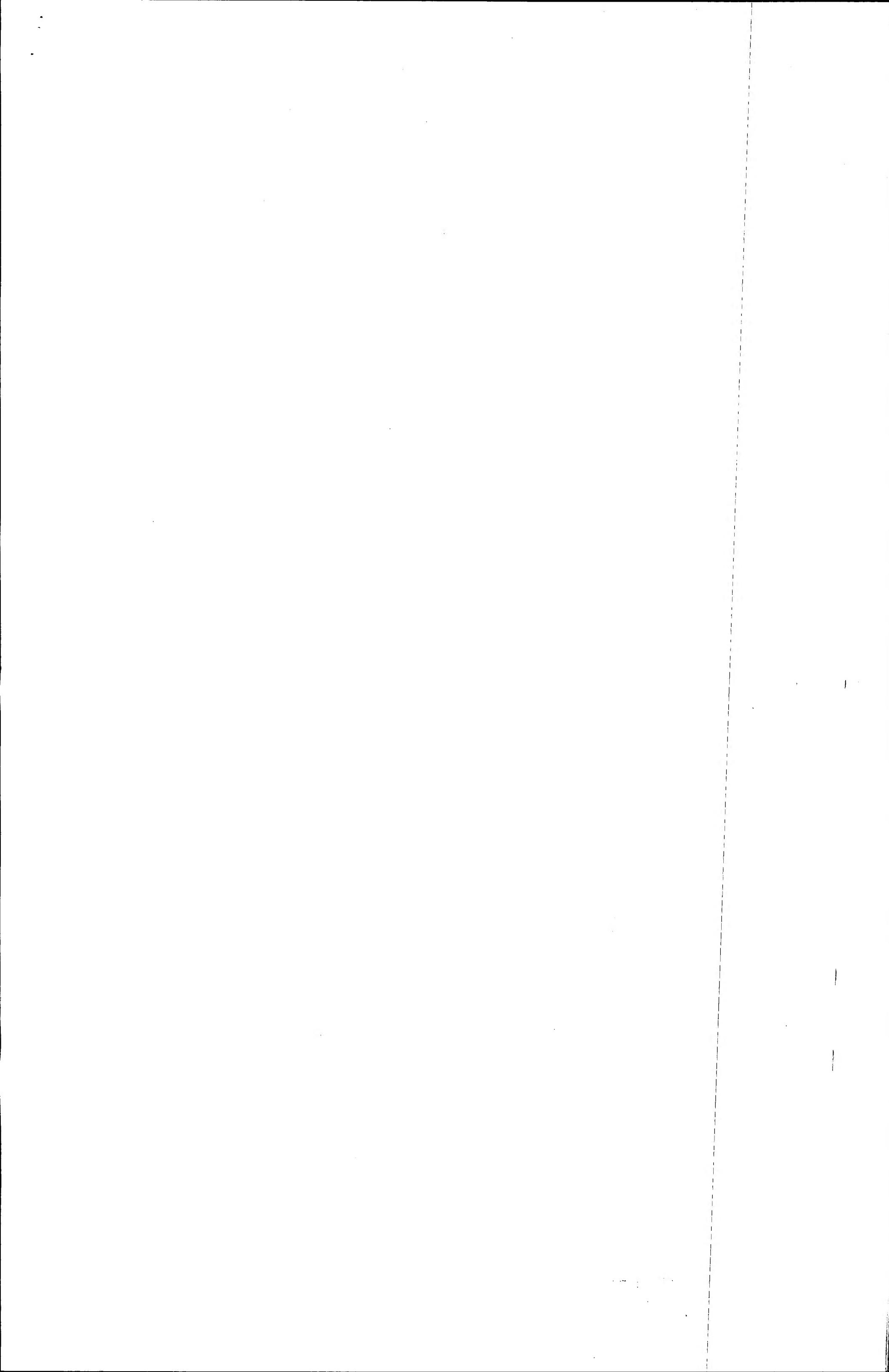
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RELEASED  
08.07.09 TAD  
40821

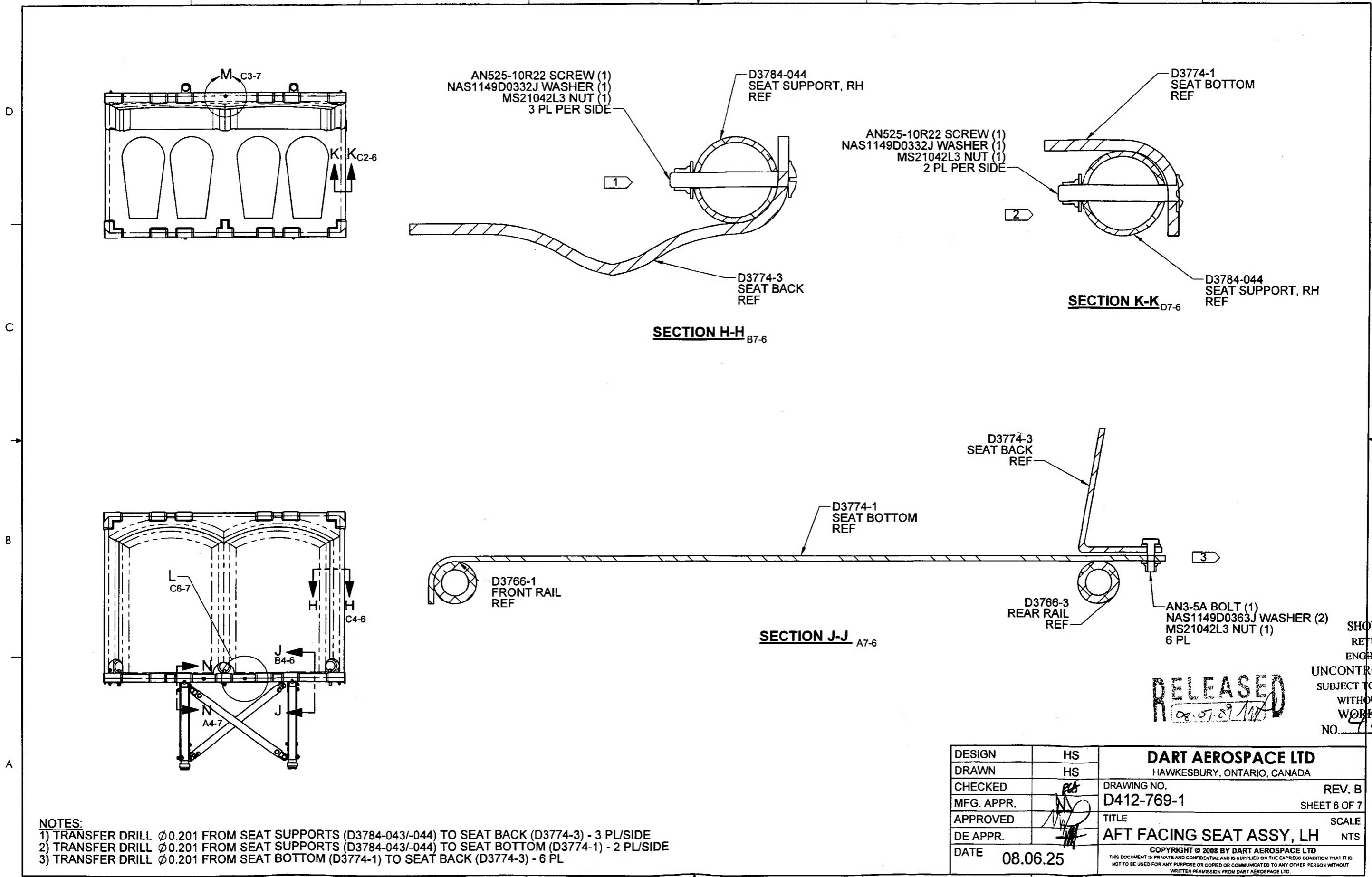
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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D412-769-1	SHEET 5 OF 7
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	AFT FACING SEAT ASSY, LH	NTS
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